

Work Order ID 56161

February 11, 2010 2:46:51 PM

Page 1

Item ID: D4042-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Rib Assembly

Start Date: 2/11/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-2-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4042

100

Weld per dwg A/R S.S. rod Batch: M109213

0.00

Large Fab

Memo

0.00

Large Fab

- ✓ 1- Cut as per dwg D4042-3
- ✓ 2- Drill and chamfer holes as per dwg D4042-3
- ✓ 3- remove identification markings
- ✓ 4- Weld bushing in rib and grind weld flush as per dwg D4043

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

~~PRELIMINARY ISSUE~~
~~PRELIMINARY ISSUE~~

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 56161

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Page 2

Item ID: D4042-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Rib Assembly

Start Date: 2/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/02/17



QC

Memo

0.00

70

Quality Control

130

Identify as per dwg & Stock Location: Basket 0.00

0.00



Packaging

Memo

0.00

Packaging

PD

10.02.19

140

QC21- Final Inspection - Work Order Release 0.00

0.00



QC

Memo

0.00

Quality Control

10/02/25

MF

10-2-19

POSITIVE RECALL

EFFECTIVE 10-2-11

RELEASED

DATE 10-02-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

February 11, 2010 2:46:55 PM

Page 1

Work Order ID: 56161



Parent Item: D4042-043



Parent Item Name: Aft Rib Assembly

Start Date: 2/11/10

Required Date: 2/19/10

Comments: IPP RevA: new issue DD 10.01.07 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D4021-9 | | Manufactured | No | | | 100 | Each | 0.0000 | 2.0000 | | | |
| | | | | | | | | | | | | |
| Bushing | | | | | | | | | | | | |
| M304TS0.750W.049 | | Purchased | No | | | 100 | f | 273.8661 | 2.1491 | | | |
| | | | | | | | | | | | | |
| 304 SQ Tube .75x.75x.049W | | | | | | | | | | | | |

B56094 → ② *Pl 10.02.17*

Pl 10.02.17

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 273.8661 | |
| 103240 | 1.5816 | |
| 106604 | 4.9307 | |
| 107460 | 29.2779 | |
| 113763 | 238.0759 | |

1 Dpl

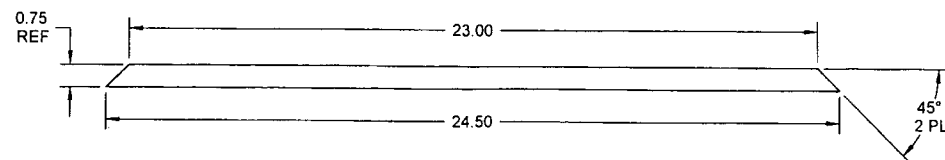
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

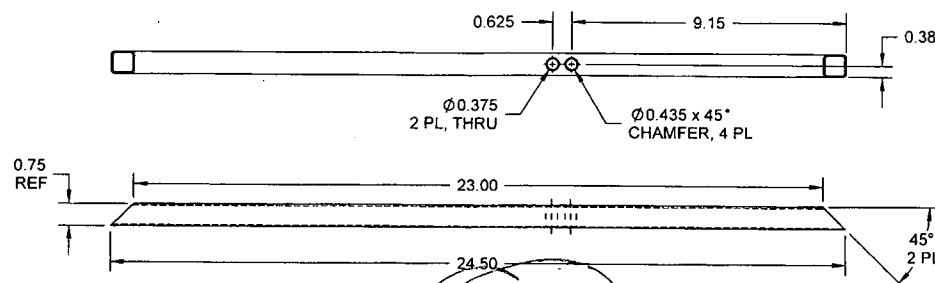
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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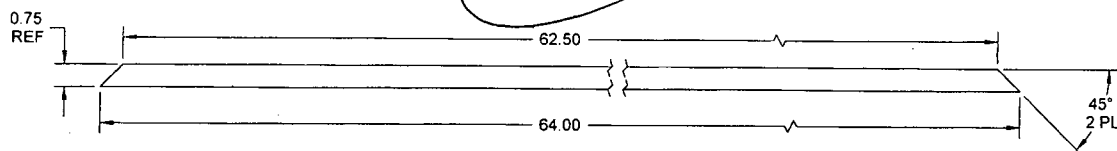
NOTE: Date & initial all entries



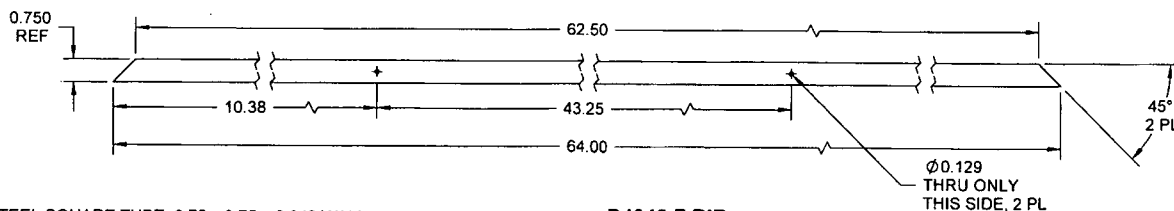
D4042-1 FWD RIB



D4042-3 AFT RIB



D4042-5 RIB



D4042-7 RIB

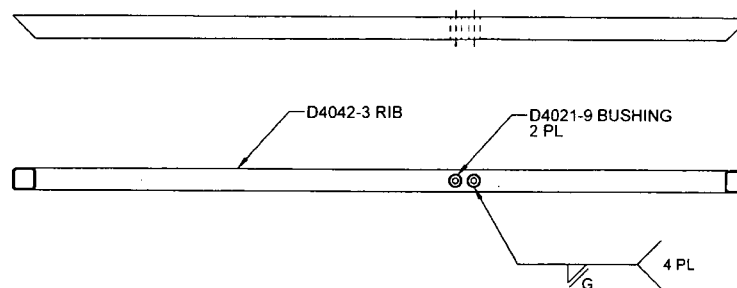
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4042-1: 0.89 lbs
D4042-3: 0.88 lbs
D4042-5: 2.36 lbs
D4042-7: 2.36 lbs

| | | | |
|------------|----------|--|----------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. A |
| MFG. APPR. | RF | D4042 | SHEET 10 OF 11 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | SHORT BASKET BASE ASSY | NTS |
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RELEASED
2010-02-16
JMD

| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-----------|------------------|
| | X | D4042-043 | RIB AFT ASSEMBLY |
| 1 | 1 | D4042-3 | AFT RIB |
| 2 | 2 | D4021-9 | BUSHING |



D4042-043 AFT RIB ASSEMBLY

WLO 56161

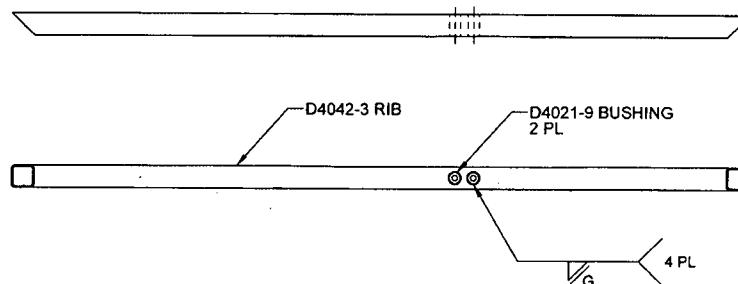
RELEASED
2010-02-16
AM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004

| | | | |
|------------|-----------------|--|---------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>RF</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>RF</i> | D4042 | SHEET 9 OF 11 |
| APPROVED | <i>RF</i> | TITLE | SCALE |
| DE APPR. | <i>RF</i> | SHORT BASKET BASE ASSY | NTS |
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| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|------------------|
| | X | D4042-043 | RIB AFT ASSEMBLY |
| 1 | 1 | D4042-3 | AFT RIB |
| 2 | 2 | D4021-9 | BUSHING |



D4042-043 AFT RIB ASSEMBLY

#56161

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.91 lbs
 - 8) WELD PER DART QSI 004

RELEASED
2010-02-16
JMP

| | | | |
|----------------------|----|--|-----------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. D4042 | REV. A |
| MFG. APPR. | RF | SHEET 9 OF 11 | |
| APPROVED | RF | TITLE SHORT BASKET BASE ASSY | SCALE NTS |
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